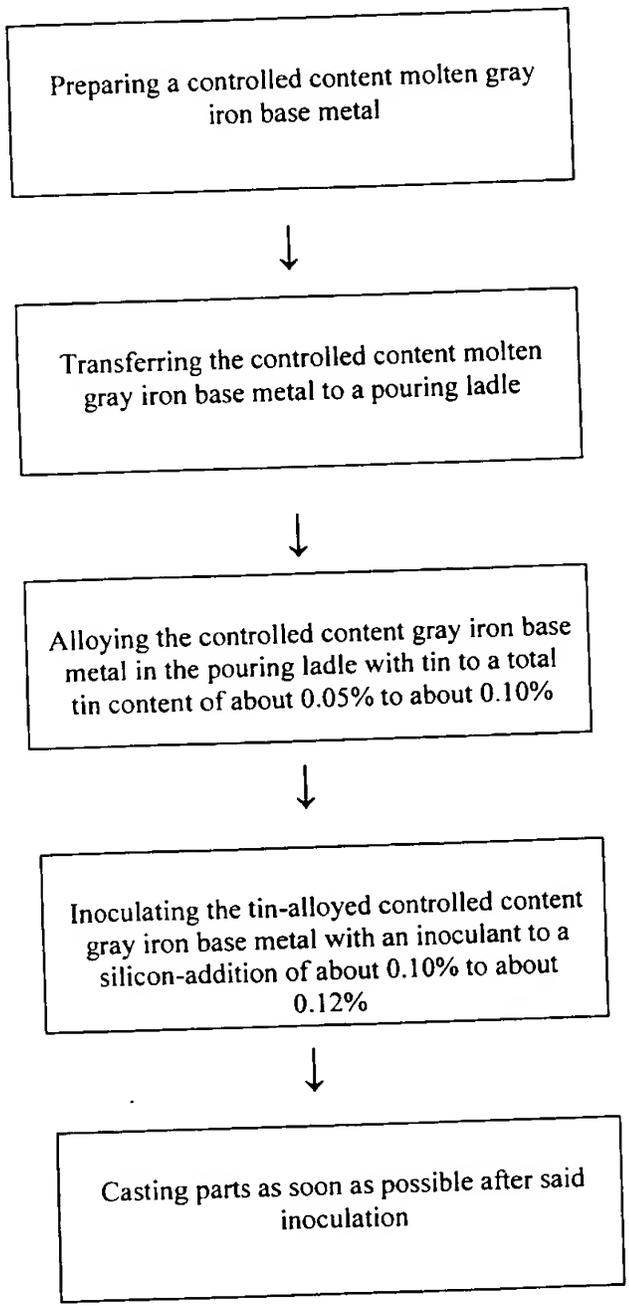
Preparing a controlled content molten gray iron base metal
Transferring the controlled content molten gray iron base metal to a pouring ladle
Alloying the controlled content gray iron base metal in the pouring ladle with tin to a total tin content of about 0.05% to about 0.10%
Inoculating the tin-alloyed controlled content gray iron base metal with an inoculant to a silicon-addition of about 0.10% to about 0.12%
Casting parts as soon as possible after said inoculation

FIG. 1